

Date: Friday, 18/04/2008 10:55:56 AM
 User: Jean-Luc Menard

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STUD UNDER REVIEW |
| Job Number : 38687 | |
| Estimate Number : 13146 | |
| P.O. Number : | Part Number : D36883 |
| This Issue : 18/04/2008 S.O. No. : | Drawing Number : D3688 UNDER REVIEW <i>Prototype</i> |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 11 Type : MACHINED PARTS | Drawing Revision : U/R |
| Previous Run : 37122 | Material : |
| Written By : <i>J. Menard 04.18</i> | Due Date : 25/04/2008 Qty: 1 Um: Each |
| Checked & Approved By : | |
| Comment : Rev:A New Issue 08-01-29 JLM Verified By:EC | |

Additional Product

PROTOTYPE

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M303R1000 | 303 Round Bar 1.0" |
|-----|-----------|--------------------|



Comment: Qty.: 0.8159 f(s)/Unit Total : 0.8159 f(s)
 303 Round Bar 1.0"
 BATCH: *M107744*

J. Menard 04.18

①

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut blank 9.324" long

J. Menard 04.18

①

| | | |
|-----|--------------|--------------|
| 3.0 | DOOSAN LATHE | DOOSAN LATHE |
|-----|--------------|--------------|



Comment: DOOSAN LATHE
 1-Turn as per Folio FA717 Rev: *A* & Dwg D3688 Rev: *rel*

J. Menard 04.18

①

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J. Menard 04.18

①

| | | |
|-----|-------------|--------------------|
| 5.0 | LATHE CONV. | CONVENTIONAL LATHE |
|-----|-------------|--------------------|



Comment: CONVENTIONAL LATHE
 Face to finished length as per dwg D3688 AND center drill as per Dwg D3688

J. Menard 04.18

①

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Part Number: D36883

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J. Menard 08.04.18 (1)

7.0

DOOSAN LATHE

DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA717 Rev: *A* & Dwg D3688 Rev: *Pre1*

2-Deburr per dwg D3688

J. Menard 08.04.18 (1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J. Menard 08.04.18 (1)

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J. Menard 08.04.18 (1)

10.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *6251*
LPI Per ASTM 1417 LEVEL 2
Certificate of conformaty is required

C208/04/290

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

P. 8/4/29

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J. Menard 08.04.29 (1)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD UNDER REVIEW

Job Number: 38687

Part Number: D36883

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Sample for testing

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01

Job Completion






08.24.30

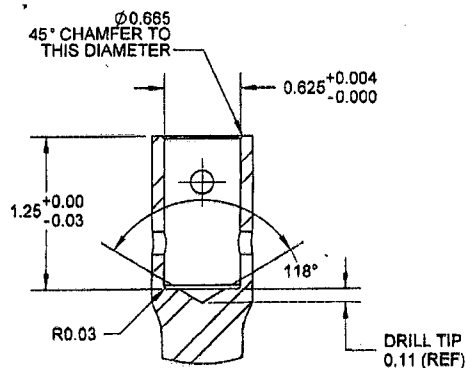
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

| | | | | | |
|--------------|---|-------------|---|---------------------|---|
| Measured by: |  | Audited by: |  | Prototype Approval: |  |
| Date: | 08-04-18 | Date: | 08-04-18 | Date: | |

| | | | | |
|-----|------|-----------|------------|----------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue | KJ/RF | |



DETAIL D
SCALE 1:1

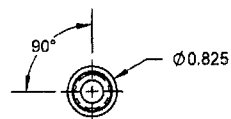
REFERENCE ONLY

ACCEPTABLE TO
CENTER DRILL
(MAX #2)

SECTION C-C

ACCEPTABLE TO
CHAMFER 45°

3/4-16UNF-2A
LH THREAD



9.324±0.015

R0.03

2.90

0.075 x 45°
CHAMFER

0.659^{+0.000}
-0.015

0.870^{+0.000}
-0.010

0.189

0.370^{+0.000}
-0.010

0.189

R0.25
R0.50

D3688-3 STUD

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R) OR AISI 304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lb
- 8) LPI PER ASTM 1417 LEVEL 2

| | | | |
|---|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | LE | DRAWING NO. | REV. A |
| MFG. APPR. | RF | D3688 | SHEET 2 OF 4 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | | STUD | 1:2 |
| DATE | 08.03.12 | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |
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m107744



LIQUID PENETRANT TEST REPORT

P - 1269 2

PAGE 1 OF 1

| | | | | | |
|------------------|--------------------------------------|-----------------|-------------------|-----------|---|
| CLIENT | DART AEROSPACE | DATE | APR 28, 2008 | TIME | AM <input type="checkbox"/> PM <input type="checkbox"/> |
| ATTENTION | LINDA LACELLE | ACUREN JOB NO. | 188 08 1269 | | |
| ADDRESS | 1270 ABERDEEN ST | PO/NO. | | | |
| | HAWKESBURY, ONT. | WORK LOCATION | HAWKESBURY | | |
| | | ACCEPTANCE STD. | ASTM 1417/QSI-038 | REV./DATE | 2005 |
| PROJECT | MACHINED PARTS. | | | | |
| ITEM(S) EXAMINED | JOB # 38684 2 SLEEVES, 38687 1 STUD. | | | | |

| | | | | |
|------------------------------------|--|-----------|------------------------|-----------|
| JOB DESCRIPTION | PROCEDURE NO. LT-0002 | REV./DATE | TECHNIQUE NO. LT-TECH2 | REV./DATE |
| PART NO. SLEEVE D36891/STUD D36883 | MATERIAL 303 | THICKNESS | | |
| SCOPE | WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% ACCESSIBLE SURFACE | | | |

TEST DETAILS

| | | | | | |
|-----------------------|---|----------------------------------|--|--|--|
| METHOD | <input checked="" type="checkbox"/> FLUORESCENT | <input type="checkbox"/> VISIBLE | <input checked="" type="checkbox"/> WATER WASH | <input type="checkbox"/> SOLVENT REMOVABLE | <input type="checkbox"/> POST EMULSIFIED |
| FAMILY BRAND | MAGNAFLUX | | BLACK LGHT8171 | <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² | <input type="checkbox"/> AMBIENT < 2 fc |
| PENETRANTZL67 | MINIMUM DWELL TIME | 45 MIN. | LIGHTING EQUIP. | <input type="checkbox"/> FLASHLIGHT | <input type="checkbox"/> TROUBLELIGHT |
| PENETRANT REMOVER H2O | MINIMUM DRY TIME | >10 MIN. | OTHER | CAL FEB 12 08 | |
| DEVELOPER SKDS2 | MINIMUM DWELL TIME | 10 MIN. | LIGHT METER S/N | CAL DUE DATE | |
| DEVELOPER TYPE | <input checked="" type="checkbox"/> NON AQUEOUS | <input type="checkbox"/> AQUEOUS | <input type="checkbox"/> DRY | | |

TEST SURFACE

| | | | | | |
|---------------------|--|---|--|---------------------------------------|--|
| SURFACE CONDITION | <input type="checkbox"/> AS GROUND | <input type="checkbox"/> AS WELDED | <input type="checkbox"/> MACHINED | <input type="checkbox"/> SHOT BLASTED | <input checked="" type="checkbox"/> CLEAN BARE METAL |
| SURFACE TEMPERATURE | <input type="checkbox"/> < - 4°C/ 20°F | <input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F | <input type="checkbox"/> 10°C/50°F TO 52°C/125°F | <input type="checkbox"/> > 52°C/125°F | |

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% ACCESSIBLE

SURFACE ON:

38684 P/N D36891 2 SLEEVES.

38687 P/N D36883 1 STUD.

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

| | | | | |
|-------------------------|----------------------------|----------------------------|------------|-----------|
| CLIENT REPRESENTATIVE | | DTR # E 19656 | | |
| TECHNICIAN (SIGNATURE): | | REPORT REVIEWED BY: | | |
| NAME (PRINT): | JASON HEWETT | NAME INITIALS | | |
| | 1 ST TECHNICIAN | 2 ND TECHNICIAN | | |
| CGSB LEVEL | 2 | SNT LEVEL | CGSB LEVEL | SNT LEVEL |
| CGSB REG. NO | 6156 | CGSB REG. NO | | |

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY